

**Work Order ID 63650**

November 8, 2010 12:51:01 PM

Page 1

Item ID: D3937-041

Accept



Setup Start



Revision ID:

Item Name: Luminescent Strip Assembly

Stop



Start Date: 11/08/10 Start Qty: 17.00



Cust Item ID:

Required Date: 11/10/10 Req'd Qty: 17.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/11/08 Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3937	B								

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3937 (Make D3937-3)  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_

2-Deburr if necessary

0.00

0.00

0.00

N/A CY 10/11/08

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

0.00

N/A pull from stock.  
 D3937-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63650**

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Item ID: D3937-041

Accept



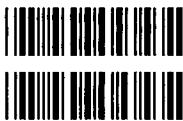
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

N/A cd vol11108

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

N/A cd vol11108

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00 N/A cd vol11108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 11/10/10 Req'd Qty: 17.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Small Fab

Memo

0.00

160



QC

Quality Control

OC5- Inspect part completeness to step on W/O

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: PPP

0.00

Memo

0.00

W/O: 63650

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE Perm. Change	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/09	# 160	change inspection levels to QC6	MM	10.11.10		8	10/11/09

Part No: D3937-041 PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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Cust Item ID:

Required Date: 11/10/10 Req'd Qty: 17.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC21- Final Inspection - Work Order Release

0.00

CL

10/11/10

QC

Quality Control

Memo

0.00

MF

10-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

November 8, 2010 12:51:01 PM

Work Order ID: 63650



Parent Item: D3937-041



Parent Item Name: Luminescent Strip Assembly

Start Date: 11/08/10

Required Date: 11/10/10

Start Qty: 17.00

Required Qty: 17.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3937-1 		Manufactured	No				Each	17.0000	1	17			

Luminescent Strip

Location	Loc Qty	Loc Code
ST097	17	
61617 ✓	17	

M4601T6S.032



Purchased

No

100 sf 57.9200 0.09099 1.628242

6061-T6 Sheet 0.032"

Location	Loc Qty	Loc Code
MAT21	57.92	
110063	3	
112763	41.12	
16954	7.9	
18375	5.9	

D 3937 -3 CL 10/11/08

B 59877

18X m.l \*  
10/11/08

B 54594

1 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

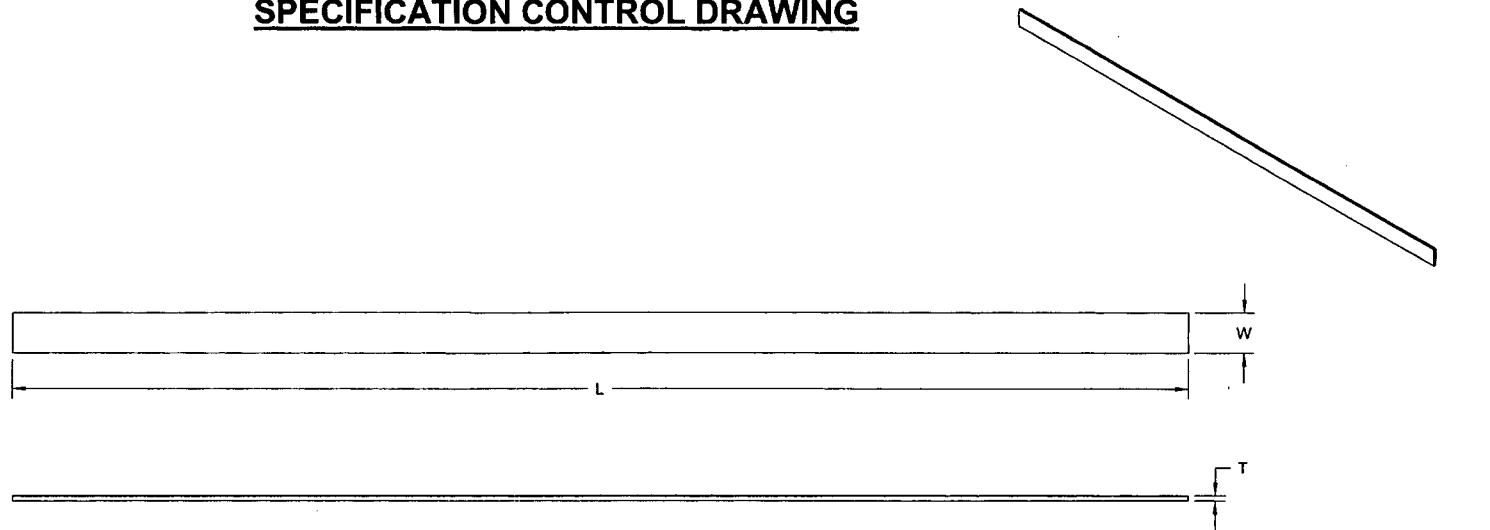
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

## SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	19.5	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

△

C2D111108

W10', 63650

RELEASED  
2009-12-02  
MM

NOTES:  
1) MATERIAL: SEE TABLE  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: SEE TABLE

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3937 REV. B
APPROVED	<i>[Signature]</i>	SHEET 2 OF 3
DE APPR.	<i>[Signature]</i>	TITLE
DATE	09.11.27	SCALE
		LUMINESCENT STRIP NTS

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8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

D

D

C

C

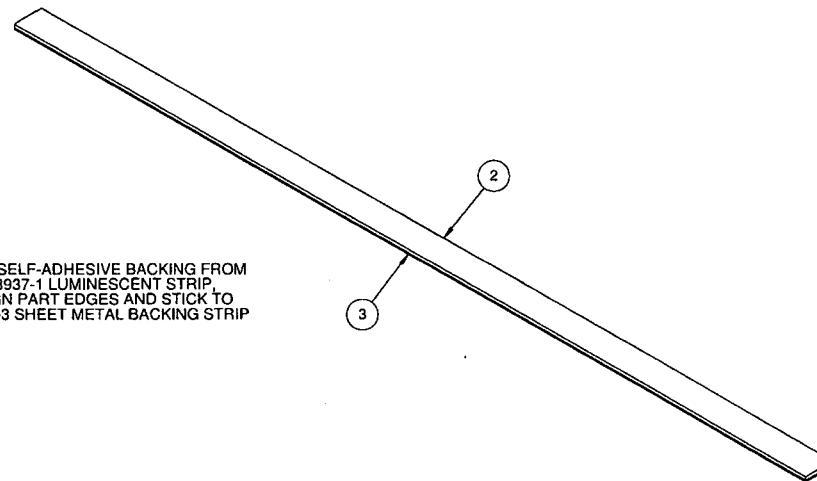
B

B

A

A

PEEL SELF-ADHESIVE BACKING FROM  
 D3937-1 LUMINESCENT STRIP.  
 ALIGN PART EDGES AND STICK TO  
 D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

RELEASED  
 2009-12-02  
*MW*

*w10.63650*

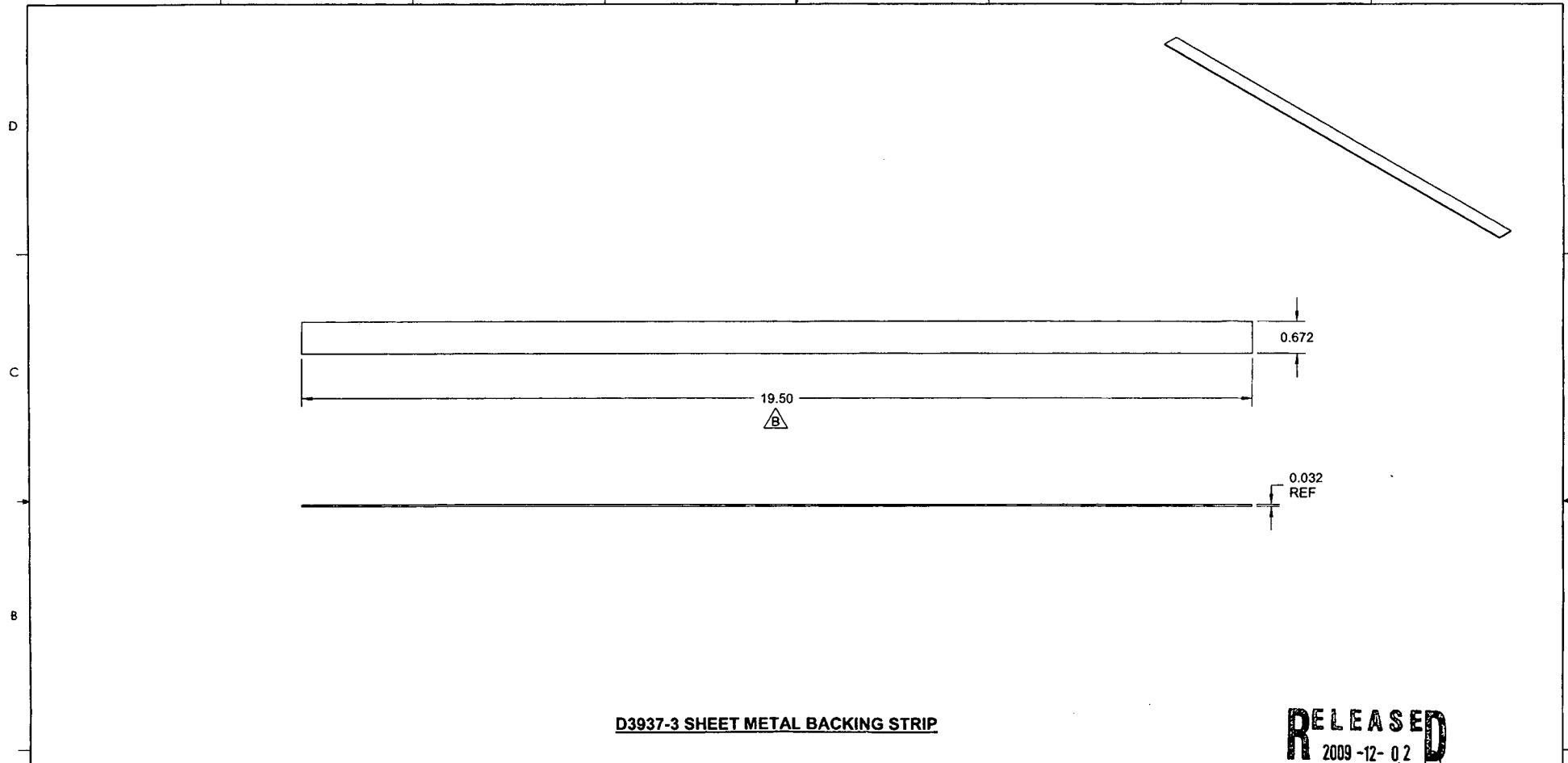
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.06 lbs

8 7 6 5 4 3 2 1

B	SHEET 2 SPEC CHART LENGTH WAS 21.0. SHEET 3 ZONE CS 19.5 DIM WAS 21.0 REASON: PREVENT EXCESSIVE WASTE.		AJS	09.11.27
A	NEW ISSUE		<i>AS</i>	09.06.02
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>AS</i>		DART AEROSPACE LTD	
DRAWN	AJS		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>		DRAWING NO.	REV. B
MFG. APPR.	<i>AS</i>		D3937	SHEET 1 OF 3
APPROVED	<i>AS</i>		TITLE	SCALE
DE APPR.	<i>AS</i>		LUMINESCENT STRIP	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D3937-3 SHEET METAL BACKING STRIPRELEASED  
2009-12-02  
*[Handwritten signature]*

W10', 63650

## A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK  
PER AMS-QC-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	D3937 SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LUMINESCENT STRIP NTS
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